

Date: Wednesday, 1/31/2007 2:18:54 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 30553	
Estimate Number : 10314	
P.O. Number : <i>N/A</i>	Part Number : D265613
This Issue : 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 29976	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/12/2007 Qty: <i>41</i> Um: Each
Checked & Approved By : <i>[Signature] 07.02.01</i>	
Comment : Est: <i>LP</i> 02.10.25 Re-format KJ/RF	
Est Rev:G Now on Waterjet 06-07-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 1 sf(s)/Unit Total : 21 sf(s)  
 1010/1025/A21/6aA SHEET

20 gauge

Batch: *M103788 (31) M103840 (10) SAN 07/04/21*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D 2656  
 Dwg Rev: *D*  
 Prog Rev: *D*

2-Deburr if necessary

*SAN 07/04/22 41*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAN 07/04/21 41*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*207.04.24 (42) counted**(PTO)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE


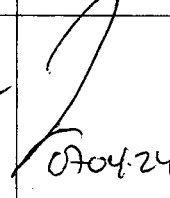
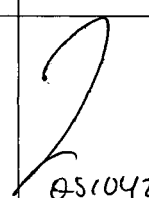
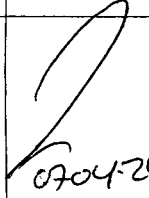
1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326  
 2-Form joggle as per Dwg D2656 using Jig DT8158Identify as D2656-13

*SB 07/05/01**(42)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/07

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/22 S	2.0	Scrap one part, machine malfunction	 05/04/22	Scrap and destroy, and replaced part 42 remaining	SAD 07/04/22	 07/04/24	 05/04/22	 07/04/24

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30553

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/04 (42)

7.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

el

07-05-03

(42)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m.l

07/05/04

(42x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP-15

07/05/04

(42x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/04

(42)

Job Completion



U 07-05-04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

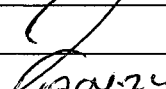
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

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 30553
<b>Description:</b> Wearshoe		<b>Part Number:</b> D2656-13
<b>Inspection Dwg:</b> D2656	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.890	✓		Vern	
5.650	+/-0.010	5.650	✓		Vern	
9.150	+/-0.010	9.146	✓		Vern	
0.300	+/-0.010	0.298	✓		Vern	
0.300	+/-0.010	0.298	✓		Vern	

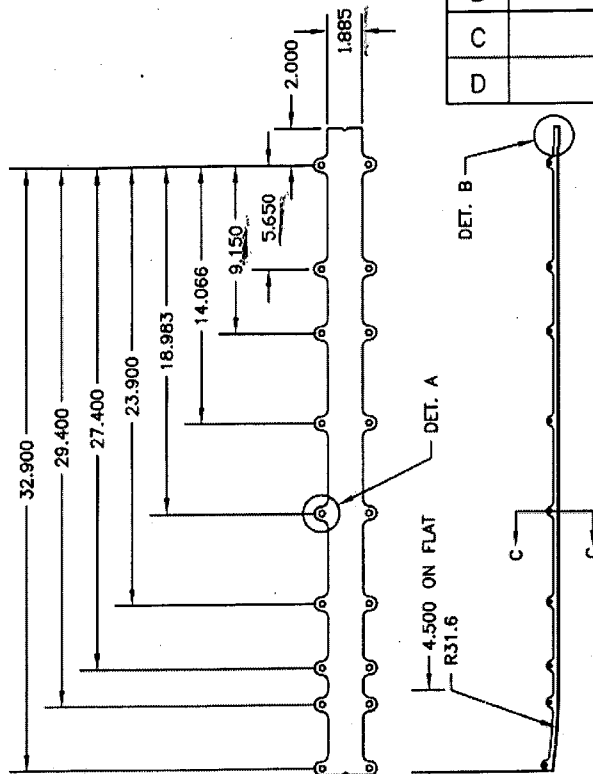
<b>Measured by:</b> SAD	<b>Audited by:</b> 	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/21	<b>Date:</b> 07-04-24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.05	New Issue	KJ/JLM 	

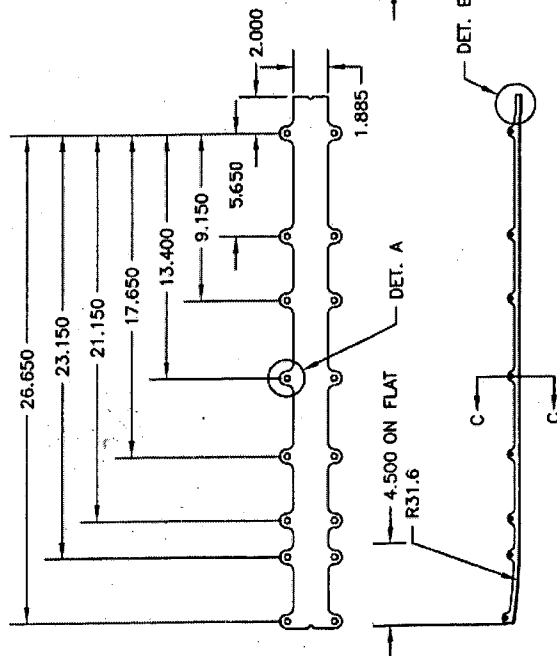


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				D2656	SHEET 1 OF 4
DATE			TITLE		SCALE
05.08.17			WEARSHOE		1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

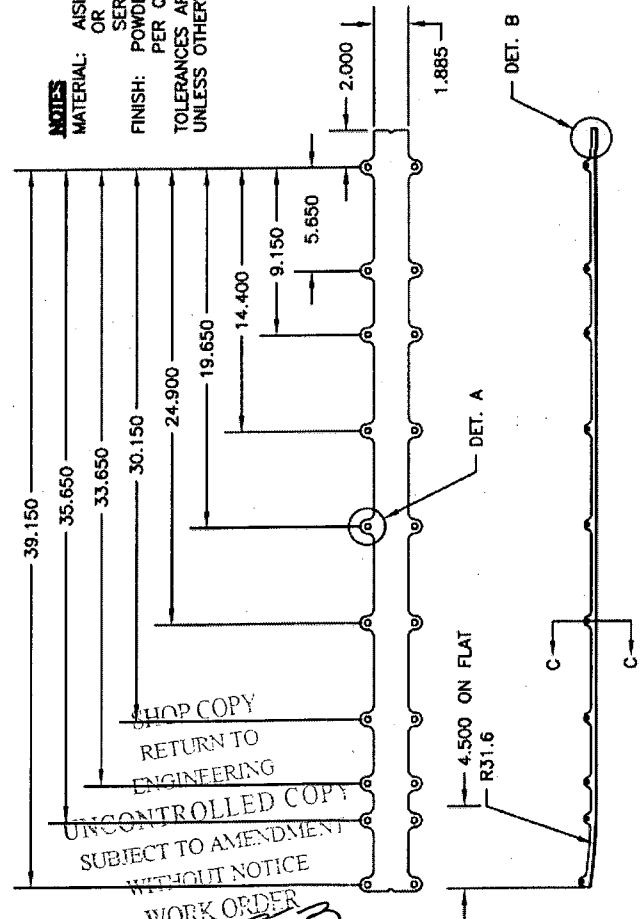
**D2656-13**



**D2656-11**



**D2656-15**



**NOTES:**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA C40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

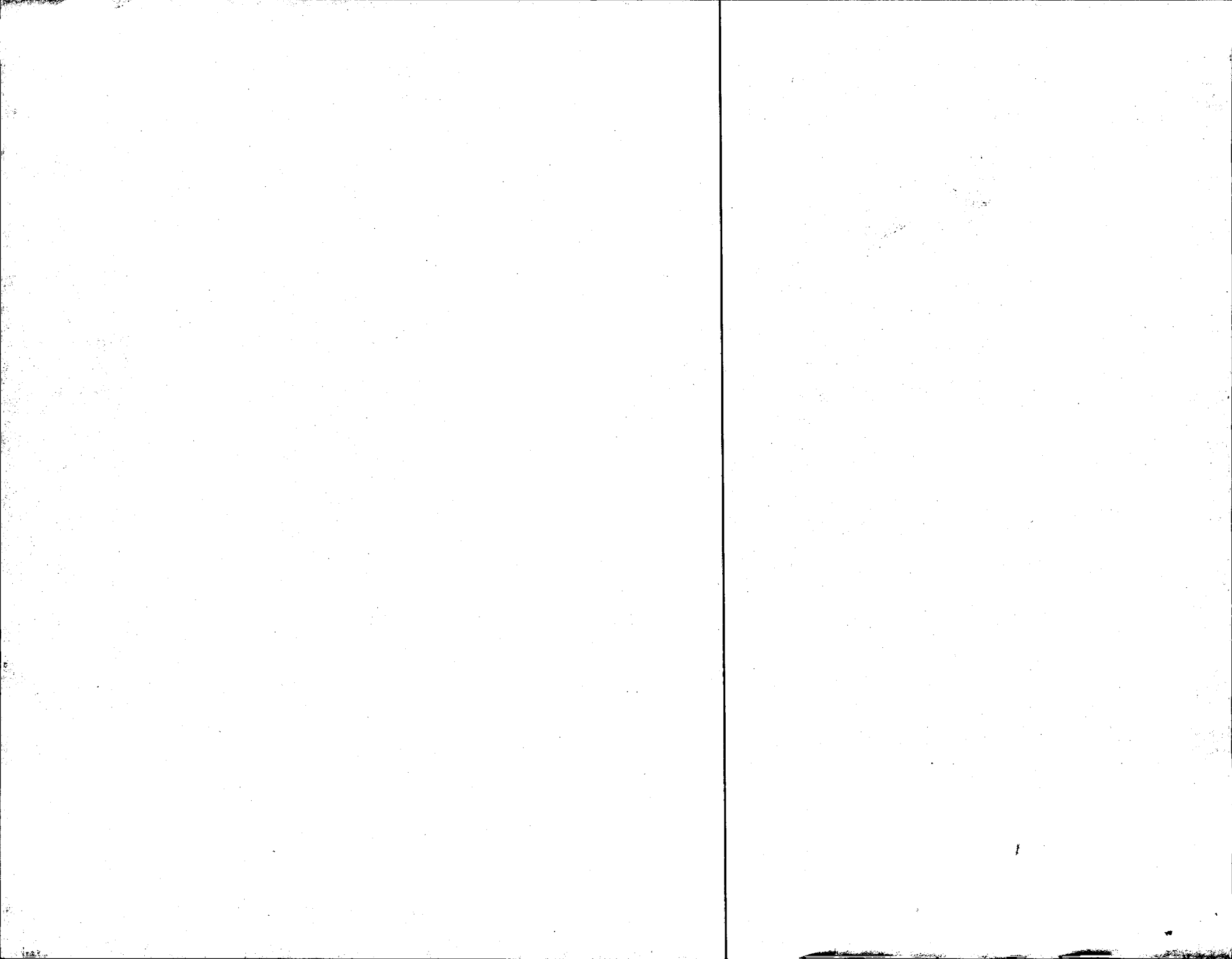
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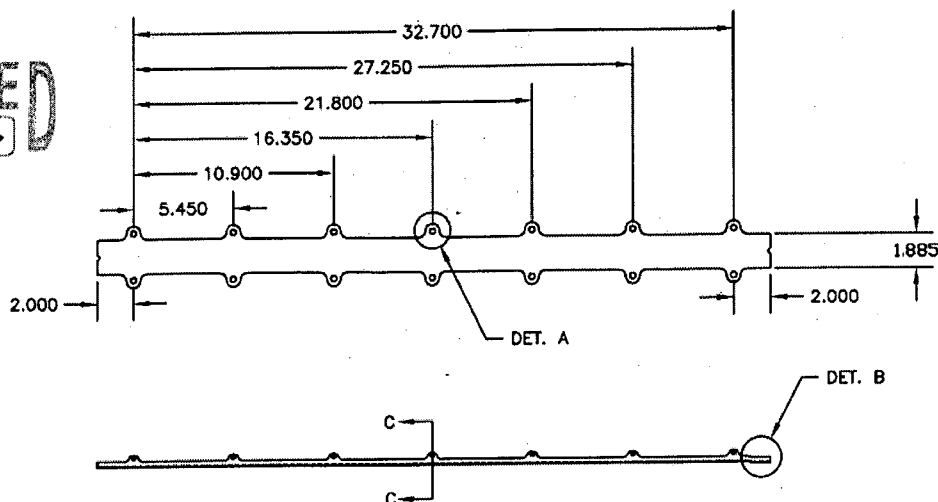




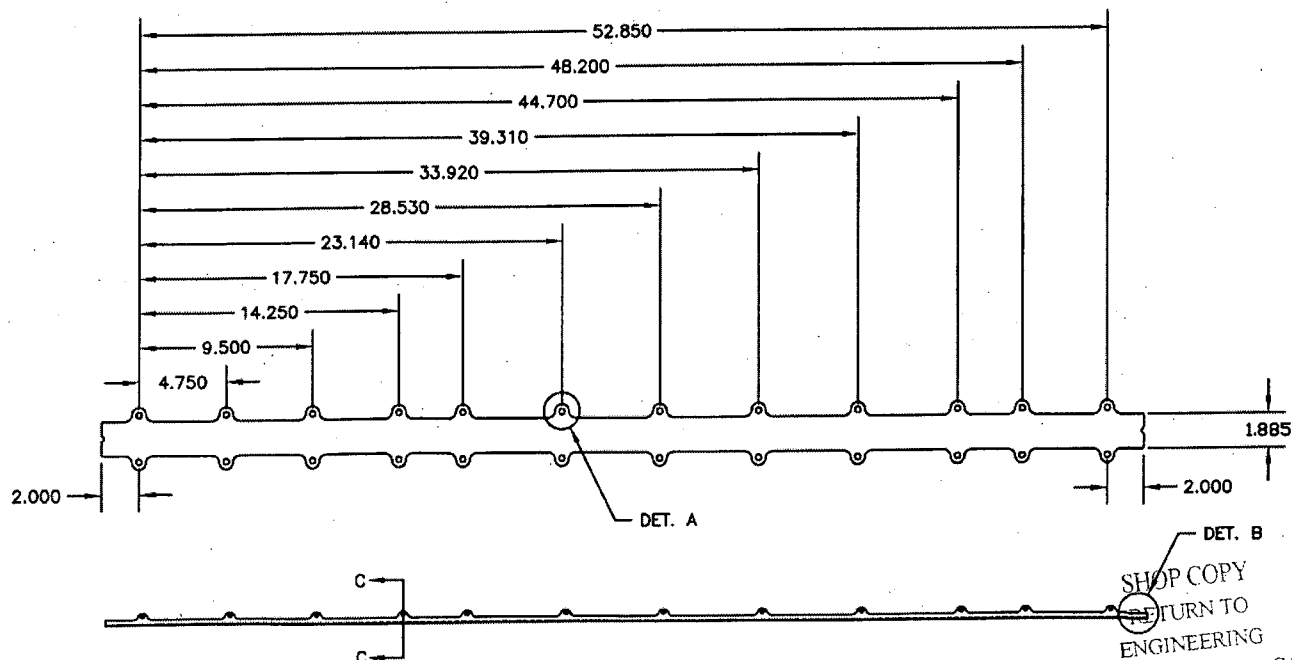
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DATE	05.08.17			SHEET 2 OF 4
		TITLE	WEARSHOE	SCALE 1:10

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### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
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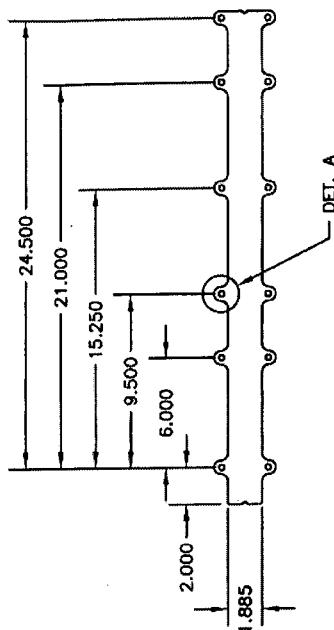
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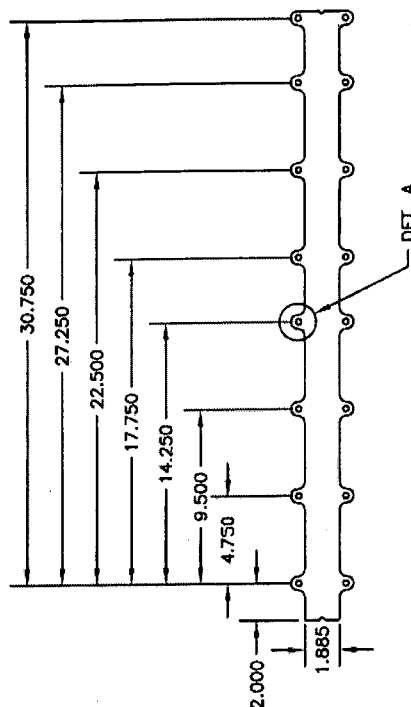


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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b> SCALE 1:10	

**D2656-33**

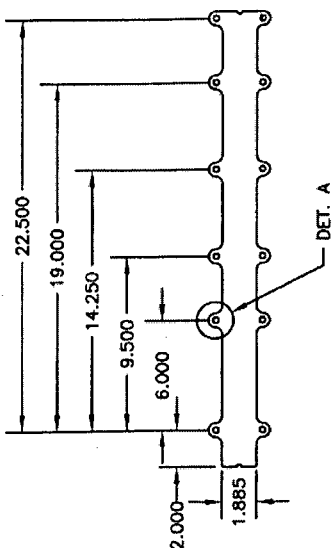


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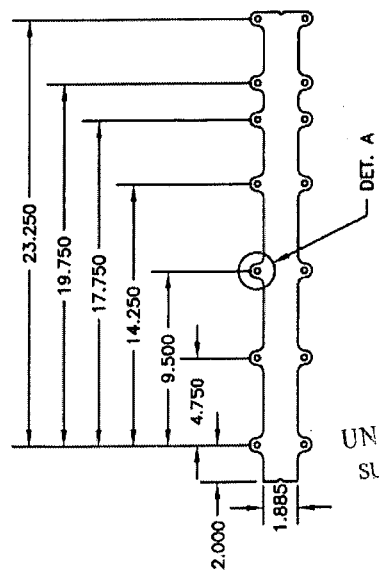


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**D2656-35**



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FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
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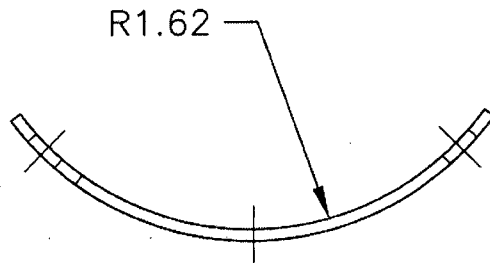
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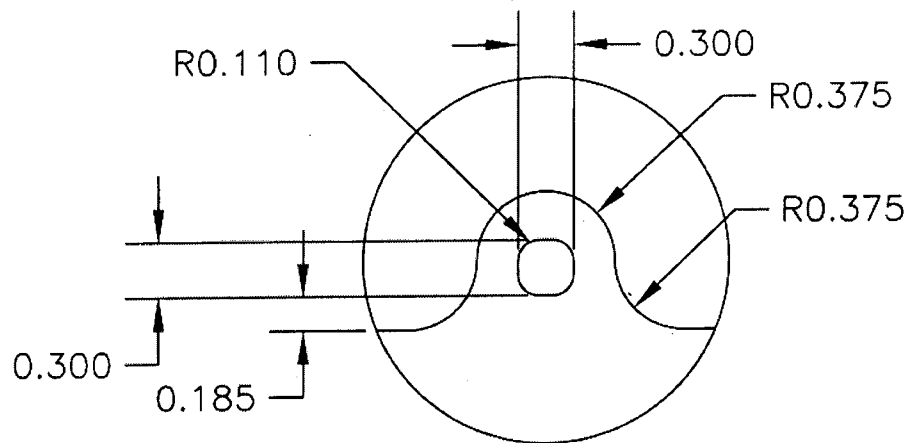
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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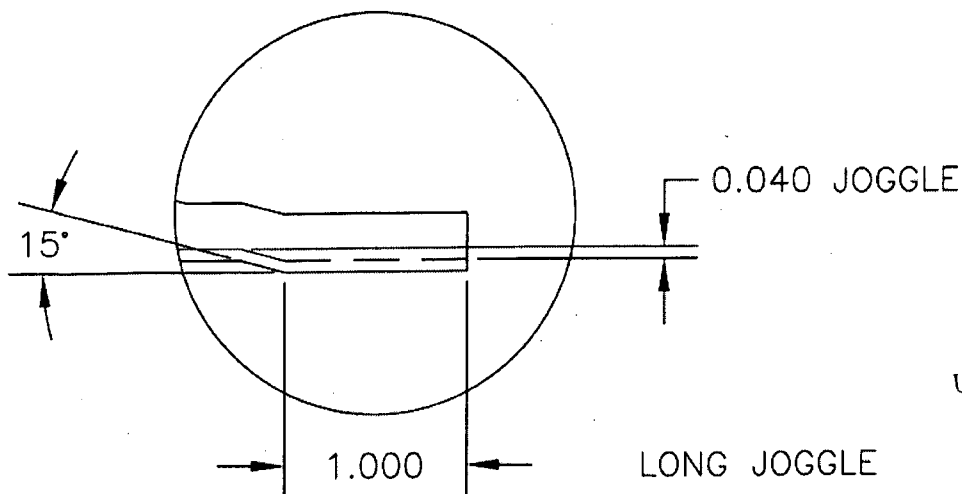


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### DETAIL B



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